

Work Order ID 64058

Tuesday, November 23, 2010 3:56:36 PM



RUSH !!!

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Item ID:	D3608-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Upper Doubler				Stop	
Start Date:	11/24/2010	Start Qty:	2.00			
Required Date:	11/25/2010	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:	<u>mt</u>	Date:	<u>10-11-23</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3608	<u>pet</u> <u>Rev C</u>								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3608 Dwg Rev: <u>pc1</u> Prog Rev: <u>pc1</u> 2-Deburr if necessary								(2)
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									(x2)

Swan/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3608-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Upper Doubler

Start Date: 11/24/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/25/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location: 175

0.00

Memo

0.00

10/11/24 SP (2X)

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/24 ME
10-11-24

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 64058



Parent Item: D3608-3



Parent Item Name: Upper Doubler



Start Date: 11/24/2010

Required Date: 11/25/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
 IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
 IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
 Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
 10.11.17 as per PC1 dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	90.2000	0.7392	1.556211			
304/316 .040 Sheet													

1810-11-24

Location	Loc Qty	Loc Code
MAT	86.2	
115762	10.2	
115953	76	
MAT20	4	
113062	1.398	
115440	2.602	

115953

2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 64088
Description: Upper Double		Part Number: D3608-3
Inspection Dwg: D3608-3, Rev: <i>pet</i>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.098	+ .004 - .001	.101	✓		V PROZ	
1.82	± .030	1.816	✓		V	
.50	± .030	.504	✓		V	
11.50	± .030	11.490	✓		V PROZ	
7.950	± .016	7.941	✓		V	
1.325	± .010	1.322	✓		V	
2.25	± .030	2.244	✓		V	
8.50	± .030	8.503	✓		V PROZ	
3.750	± .010	3.747	✓		V	
1.256	± .016	1.253	✓		V	
6.82	± .030	6.819	✓		V	
2.46	± .030	2.454	✓		V	
7.07	± .030	7.077	✓		V	
11.63	.030	11.616	✓		V PROZ	
2.28	.030	2.281	✓		V	
1.44	.030	1.438	✓		V	
8.56	.030	8.561	✓		V PROZ	
2.00	.030	2.006	✓		V	
.040	.010	.035	✓		V	

Measured by: <i>IB</i>	Audited by: <i>S</i>	Prototype Approval:
Date: 16-11-24	Date: 10/11/24	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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